

Date: Monday, 10/16/2006 2:01:58 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PLUG
<b>Job Number</b> : 29018	
<b>Estimate Number</b> : 12338	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3492045
<b>This Issue</b> : 10/16/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3492 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 28276	<b>Material</b> : N/A
<b>Written By</b> : _____	<b>Due Date</b> : 11/5/2006 <b>Qty:</b> 40 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JA 06/10/16</u>	
<b>Comment</b> : Est Rev: A 06.03.21 New Issue JLM Est Rev: B 06-08-28 As per Rev B JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M6061T6R0500	6061-T6 Round Bar .500"
-----	--------------	-------------------------

**Comment:** Qty.: 0.0656 f(s)/Unit Total: 2.6250 f(s)

6061-T6 Round Bar .500"

(M6061T6R500)

Batch: M 10/421

M19296 16"

16"

HARDINGE CNC LATHE SMALL

2.0 HARDINGE

**Comment:** HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA634 &amp; Dwg D3492

Dwg Rev: B

Folio Rev: A

INSPECT PARTS AS THEY COME OFF MACHINE

3.0 QC2

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

**Comment:** SECOND CHECK

5.0 SMALL FAB 1

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

45

m 06/10/20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 10/16/2006 2:01:59 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 29018

Part Number: D3492045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*JK 06/10/23 x 44*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(Flat End Only)

*9.11 06/10/24 (44)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FC 06 10 25 (44)*

9.0

NAS1611003

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-003 O-RING

*~~10 X 101224~~ M102170*

*FC 07 01 11 (44) P10*

*005*

*~~10 X 101699~~*

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube

A/R 55-O'Ring Lube Batch: *101223*

*FC 07-01-11 (44)*

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*IM 07 01 11*

*(44)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

*FP15 IM 07 01 11*

*(44)*

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/10/11*

*IM 07.01.11*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-01-11	9.0	NAS1611-005 is needed for the plug. Make permanent change. <i>[Signature]</i>	U Est. Chg'd	07-01-11		<i>[Signature]</i> 07-01-11	<i>[Signature]</i> 07-01-11

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

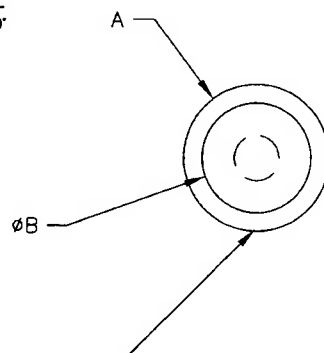
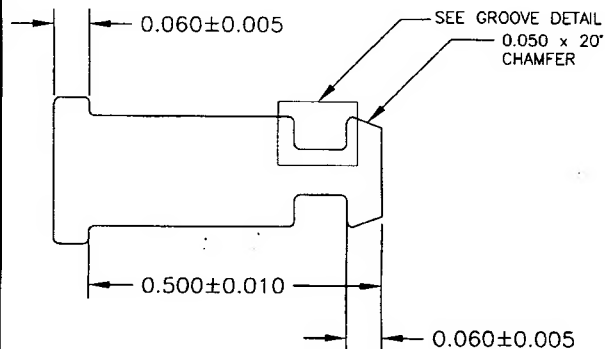
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

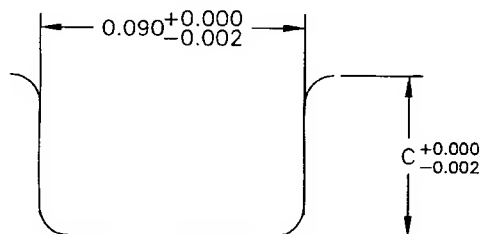
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





D3492-1/-3/-5/-7 PLUGS IN ACCORDANCE WITH TABLE 1



GROOVE DETAIL

TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500

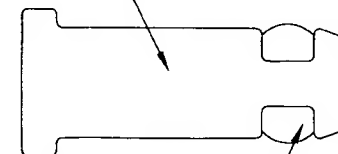


D3492-1/-3/-5/-7 PLUG NOTES

- MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6RD.DDD)
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- BREAK ALL SHARP CORNERS 0.010 MAX

NO. 29018  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

D3492-1/-3/-5/-7 PLUG IN ACCORDANCE WITH TABLE 2



NAS1611-005/-007/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

D3492-041/-043/-045 PLUG ASSEMBLY

RELEASED  
06.10.03  
REV. 604 #351

D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST  
(TABLE 2)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D3492-041	PLUG ASSEMBLY
	X			D3492-043	PLUG ASSEMBLY
		X		D3492-045	PLUG ASSEMBLY
			X	D3492-047	PLUG ASSEMBLY
1				D3492-1	PLUG
	1			D3492-3	PLUG
		1		D3492-5	PLUG
			1	D3492-7	PLUG
		1		NAS1611-005	O-RING
			1	NAS1611-007	O-RING
1				NAS1611-010	O-RING
	1			NAS1611-013	O-RING



COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

B	06.05.11	ADD -047; UPDATE DIM A, -045
A	06.01.04	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	APPROVED	DRAWING NO. D3492
DATE	06.05.11	TITLE PLUG
		REV. B SHEET 1 OF 1 SCALE NTS